

Work Order ID 62563

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Page 1

Item ID: D2739

Revision ID:

Item Name: 350 I Beam

Start Date: 10/04/10 Start Qty: 8.00

Required Date: 10/05/10 Req'd Qty: 8.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2739

Rev D

100

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Cut D2600-5 to length as per Dwg D2739.
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
3-Use uni-bit to open holes to finish size as per Dwg D2739.
4-Bevel Fwd end of extrusion and Deburr holes and ends.
5-Deburr

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

x 8

JE 10/10/07

x 8

B 10/10/12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Item ID: D2739

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 I Beam

Start Date: 10/04/10 Start Qty: 8.00



Cust Item ID:

Required Date: 10/05/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DP

10-10-13

8

140



Packaging

Packaging

Identify as per dwg & Stock Location: 46

Memo

0.00

0.00

DP

10-10-13

8

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/10/13
MF
10-10-13

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 62563

Parent Item: D2739

Parent Item Name: 350 I Beam



Start Date: 10/04/10

Required Date: 10/05/10

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev: C 02-11-28 Reformat KJ
 IPP Rev: D 06-03-21 As Per Rev C JLM
 IPP Rev: E 07-07-28 As per Rev D JLM Verified By:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2600-5-108 | | Manufactured | No | | | 100 | Each | 149.0000 | 1 | 8 | | | |



Extrusion 'I Beam' thin



Location

Loc Qty

Loc Code

LG

149

47814

149

B 88 10/10/07

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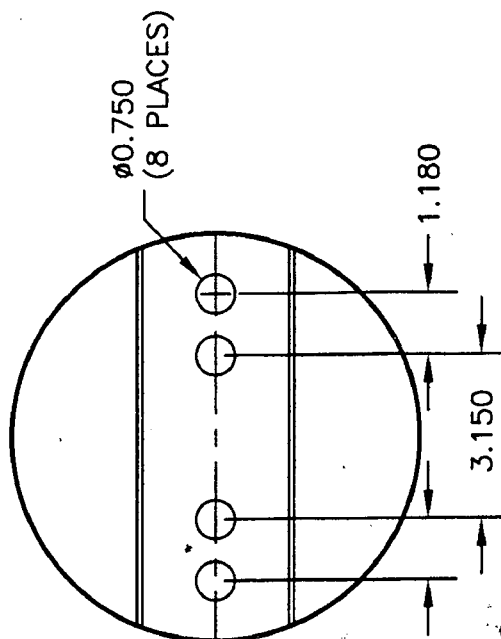
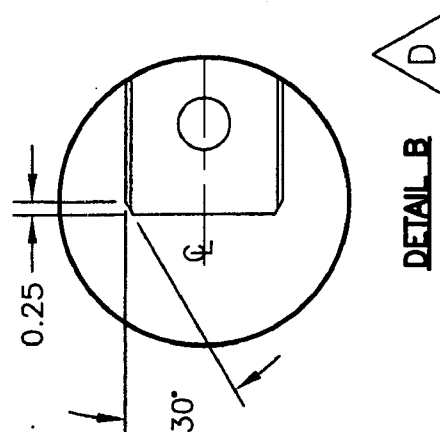
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NOTE: Date & initial all entries

RELEASED
07 08-02

Technical drawing of a vertical plate with the following specifications:

- Overall Dimensions:**
 - Width: 78.76
 - Height: 56.15
- Hole Specifications:**
 - Top Section:** 2 holes, diameter $\phi 0.625$ (2 PLACES), spacing 1.125.
 - Middle Section:** 2 holes, diameter $\phi 0.750$ (2 PLACES), spacing 1.125.
 - Bottom Section:** 17 holes, diameter $\phi 1.00$ (17 PLACES), spacing 1.125.
- Dimensions and Spacing:**
 - Top hole to top edge: 0.00
 - Between top and middle holes: 7.88
 - Between middle and bottom holes: 10.07
 - Between bottom hole and bottom edge: 16.54
 - Between bottom hole and bottom edge: 20.87
 - Between bottom hole and bottom edge: 25.20
 - Between bottom hole and bottom edge: 29.53
 - Between bottom hole and bottom edge: 32.65
 - Between bottom hole and bottom edge: 35.35
 - Between bottom hole and bottom edge: 38.35
 - Between bottom hole and bottom edge: 41.35
 - Between bottom hole and bottom edge: 44.35
 - Between bottom hole and bottom edge: 47.40
 - Between bottom hole and bottom edge: 50.15
 - Between bottom hole and bottom edge: 52.90
- References:**
 - SEE DETAIL A (pointing to the bottom hole)
 - SEE DETAIL B (pointing to the top hole)
 - SEE DETAIL C (pointing to the middle hole)
- Notes:**
 - 25.80 10
 - 20.80 10



DETAIL B

DETAIL A

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT C

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